

Work Order ID 128543

128543

Page 1

Monday, January 19, 2015 7:59:16 AM

Item ID: D145-762-013 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Skidtube with Standard Wearplates Fits LH or RH Stop *NS2*

Start Date: 1/19/2015 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 1/19/2015 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: MLJ Date: 15-01-19 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D117-762	c

100 0.00

100 DOCUMENT CONTROL

DC Memo 0.00

Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D145-762-013 CHG003

DAS 6 9-89 MAY 14 2015

110 0.00

110 Pick Kit

Packaging Memo 0.00

Packaging

DAS 27 9-89 MAY 13 2015

120 0.00

120 QC4- 100% Inspect kits for completeness

QC Memo 0.00

Quality Control

DAS 6 9-89 MAY 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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128543

Page 2

Item ID: D145-762-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Stop ***NS2***Start Date: 1/19/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/19/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D145-762-013

Location: 681DA
6
9-89145
28
9-89

MAY 14 2015

140

140

QC

Quality Control

QC21 - Final Inspection - Work Order Release

0.00

Memo

0.00

MLJ

MAY 15 2015

MLJ

MAY 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Monday, January 19, 2015 7:59:19 AM

128543

D145-762-013

Required Date: 1/19/2015

Required Qty: 1.00

Comments: IPP REV:A 13.04.24 NEW ISSUE DD VERF:JLM IPP REV:B
13.11.14 AS PER IIN REV.C DD VERF:JLM IPP REV:C 14.11.24 as
per ecn14-654/chg003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D145-762-043		Manufactured	No			110	Each	0.0000	1	1			DAS 28- 9-89
D145-762-043 Replacement Std Skidtube DAS 6 9-89													
D145-762-053		Manufactured	No			110	Each	0.0000	1	1			DAS 28 9-89
D145-762-053 Replacement Wearplates for Standard Skidtubes Fit LH or RH DAS 6 9-89													
AN6C51A		Purchased	No			110	Each	13.0000	2	2			
AN6C51A BOLT DAS 6 9-89													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				DAS 27 9-89	DAS 28 9-89
				ST333		13							
				<u>m130159</u>		13				2			
D3864-1		Manufactured	No			110	Each	63.0000	4	4			DAS 27 9-89
D3864-1 Bushing DAS 6 9-89													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST062		63							
				105463		3							
				<u>109111</u>		60				4			

DQA: _____ Date: _____



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Picklist Print

Page 2

Monday, January 19, 2015 7:59:19 AM

Work Order ID: 128543

128543

Parent Item: D145-762-013

D145-762-013

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 1/19/2015

Required Date: 1/19/2015

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

110

Each

162.0000

2

2

MS21043-6

DAS
27
9-89

NUT

DAS
6
9-89

Location

Loc Qty

Loc Code

FG	20
103693	20
FP001	142
m130325	2
m130726	140

M132 Key

2

MAY 13 2015

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Monday, January 19, 2015 7:59:16 AM

128543

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 1/19/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/19/2015 Req'd Qty: 1.00 * 1 *

Customer:

Reference:

Approvals: Process Plan: MCS Date: 15-01-19 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DRAWING CONTROL	0.00							MAY 13 2015
DC	Memo	0.00							
Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D145-762-013 CHG003									
110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

5.2 D145-762-013/-113 Skidtube Parts List

Item	Qty -013	Qty -043	Qty -053	Qty -113	Qty -153	Part Number	Description
	X					D145-762-013	SKIDTUBE WITH STD WEARPLATES
	1	X		1		D145-762-043	REPLACEMENT STD SKIDTUBE
	1		X			D145-762-053	REPLACEMENT WEARPLATES (STD SKIDTUBES)
				X		D145-762-113	SKIDTUBE WITH RUN-ON-LANDING WEARPLATES
				1	X	D145-762-153	REPLACEMENT RUN-ON-LANDING WEARPLATES (STD SKIDTUBE)
101		1				D4680-041	SKIDTUBE ASSEMBLY
102	2			2		**L321M1024101 OR **B321M1026101	SKID SHOE (REF ONLY)
103	8			8		**BRSP96/25-SK-WS-1 TEILIG OR **BRSP98/25-SK-WS-1 TEILIG OR **01618266098	CLAMP (REF ONLY)
104	8			8		**N/A	OEM BOLT (REF ONLY)
105	8			8		**N/A	OEM LOCKING WASHER (REF ONLY)
106	8			8		**N/A	OEM WASHER (REF ONLY)
110A		1				*D2965	CAP
110B		1				*D2965-3	CAP
111		4				***AELS-1032-225	INSERT
112		2				*AN3C5A	BOLT
113		2				*AN960C10L	WASHER (OR NAS1149C0332R)
114		2				*AN526C1032	SCREW
120A			X			D4682-041	WEARPLATE
120B			1			D4682-043	WEARPLATE
120C			1			D4682-7	WEARPLATE
121A					1	D4769-041	WEARPLATE
121B					1	D4773-041	WEARPLATE
121C					1	D4771-041	WEARPLATE
122			12		12	D4764-1	BUSHING
123			6		6	AN4C42A	BOLT
124			6		6	MS21043-4	NUT
130		3				*AELS-1032-130	INSERT
131		3				*AN3C4A	BOLT
132		3				*AN960JD10L	WASHER (OR NAS1149D0332J)
140		4				*D3492-055	PLUG ASSEMBLY
141		4				***NAS1611-015	O-RING
150	2			2		AN6C51A /	BOLT
151	4			4		D3864-1	BUSHING
152	2			2		MS21043-6	NUT

* PART IS INCLUDED WITH D4680-041 STD SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE